

Work Order ID 80670

\*80670\*

Page 1

February-24-12 3:30:40 PM

Item ID: D4434-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/27 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4434

12-537

100

0.00

\*100\*

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B12-3-8

B12-3-9

(B)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

Quality Control

0.00

B12-3-9

(1)

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*80670\***

February-24-12 3:30:40 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:**

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Date:

Stop \*NR2\*

Date:

**Insp.  
Stamp**

**\*120\***

QC

## Memo

0,00

## Quality Control

130

Bend as per dwg

0.00

**\*130\***

Brake NC

Brake NC

## Memo

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D4434-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd inboard Bracket Assembly  
 Start Date: 24/02/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
*160*									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
*170*									
QC	Memo	0.00							
Quality Control									
180		0.00							
*180*									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg, do not install grommets and rubber seal.								

(13) NG 12-3-19

13 X 4 M/L 12/3/20

(13) FF 12-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 4

February-24-12 3:30:40 PM

Item ID: D4434-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd inboard Bracket Assembly  
 Start Date: 24/02/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8/2/03/27		(13)			
190 *190* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo S- 9h25 T- 320°F F- 9h55	0.00 0.00		m117338		13	Q	OP	12/03/28
200 *200* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				13		14	12-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**\*80670\***

February-24-12 3:30:40 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 24/02/2012      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 15/03/2012      **Req'd Qty:** 10.00

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

**\*202\***

0.00

### Small Fab

## Memo

Install rubber seals and grommets.

3M 1300 batch: 1120954

0.00

\*205\*

0.00

QC

## Memo

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

**\*210\***

0.00

## Packaging

## Memo

## Packaging

Identify as per dwg & Stock Location. GA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*80670\***

February-24-12 3:30:40 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**\*10\***

**\*10\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Insp. .  
Stamp

**\*220\***

0.00

Qty Number Stamp  
12/3/29 AJ

ME  
12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-24-12 3:30:44 PM

Page 1

Work Order ID: 80670

\*80670\*

Parent Item: D4434-043

\*D4434-043\*

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB  
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24  
per REV.A DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

294.9670

2.5

26.31579

\*M6061T6S 040\*

6061-T6 .040 Sheet

\*\*

B(2-3-9)

Location

Loc Qty

Loc Code

MAT021

294.967

117653

27.91

120154

90

120218

177.057

120219

D4434-9

Manufactured

No

180

Each

1.0000

1

10

\*D4434-9\*

Bracket

\*\*

3  
10

(13) FF 12-03-26

Location

Loc Qty

Loc Code

GA

1

79508

1

D4435-041

Manufactured

No

180

Each

1.0000

1

10

\*D4435-041\*

Bracket Assembly

\*\*

10  
\*  
2  
1

(13) FF 12-03-29

Location

Loc Qty

Loc Code

ST139B

1

79371

1

80676  
80678  
80677

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Picklist Print

Page 2

February-24-12 3:30:44 PM

Work Order ID: 80670

\*80670\*

Parent Item: D4434-043

\*D4434-043\*

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4441-1 Manufactured No

202

f

24.7270

0.142

1.42

\*D4441-1\*

\*\*

Rubber Seal

(13) FF 12-03-29

LocationLoc QtyLoc Code

prelim

24.727

74760

24.727

79385

1.846

Cut qty 1 to 1.7"

D4441-1 Manufactured No

f

24.7270

2.08

\*D4441-1\*

\*\*

Rubber Seal

(13) FF 12-03-29

LocationLoc QtyLoc Code

prelim

24.727

74760

24.727

79385

2.704

Cut qty 1 to 2.5"

D4441-1 Manufactured No

f

24.7270

18.75

\*D4441-1\*

\*\*

Rubber Seal

(13) FF 12-03-29

LocationLoc QtyLoc Code

prelim

24.727

74760

24.727

79385

24.375

Cut qty 1 to 22.5"

D4440-1 Manufactured No

202

Each

20.0000

1

10

\*D4440-1\*

\*\*

Grommet

(13) FF 12-03-29

LocationLoc QtyLoc Code

prelim

2

74759

2

PREst

8

77917

8

ST139F

10

79372

10

13

February-24-12 3:30:44 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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February-24-12 3:30:44 PM

Page 3

Work Order ID: 80670

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

\*80670\*

\*D4434-043\*

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN525-832R6

Purchased

No

180

Each

511.0000

3

30

\*AN525-832R6\*

Screw

\*\*

(13) FF 12-03-29

Location

Loc Qty

Loc Code

ST345

511

120308

11

120560

500

39

180

Each

18,319.00

12

120

\*\*

(13) FF 12-03-29

MS20426AD3-2

Purchased

No

\*MS20426AD3-2\*

Rivet

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

4 121 011  
11 119 109

87

69

180

Each

2,749.000

2

20

\*\*

(13) FF 12-03-29

MS20426AD3-3

Purchased

No

\*MS20426AD3-3\*

Rivet

Location

Loc Qty

Loc Code

ST316

2749

119109

2246

19099

503

104374

26

180

Each

5,874.000

5

50

\*\*

(13) FF 12-03-29

MS20470AD4-3

Purchased

No

\*MS20470AD4-3\*

Rivet - Universal Head

Location

Loc Qty

Loc Code

Mezz

5874

1642

1240

2193

4634

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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February-24-12 3:30:44 PM

Work Order ID: 80670

\*80670\*

Parent Item: D4434-043

\*D4434-043\*

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS21075L08

Purchased

No

180

Each

364.0000

7

70

\*MS21075L 08\*

\*\*

(13) FF 12-03-29

ANCHOR NUT

Location

Loc Qty

Loc Code

ST303

302

111578

2

120560

300

ST304

62

120121

62

91

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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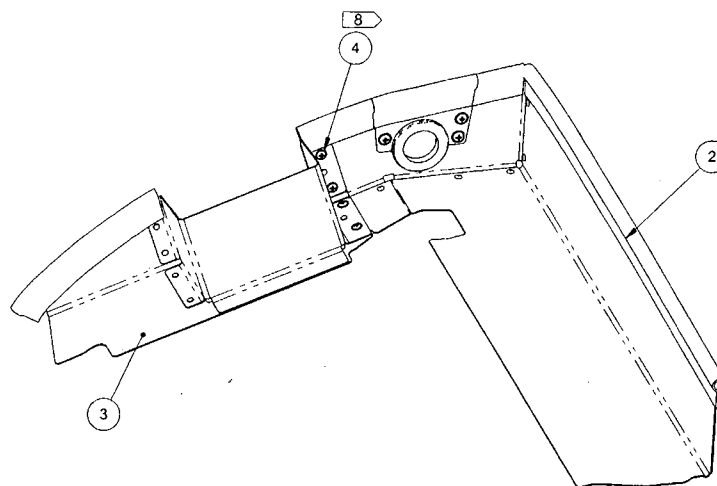
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**NOTE:** Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



w/o 80670

RELEASED  
R 2012-03-02  
JMM

# **D4434-041 FWD BRACKET ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

B	RE-DESIGN D4434-9/-9F (ZN B5-14, A5-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	E	D4434	SHEET 1 OF 15
APPROVED	MD	TITLE	SCALE
DE APPR.	JMM	COVER ASSEMBLY	NTS
DATE	12.02.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

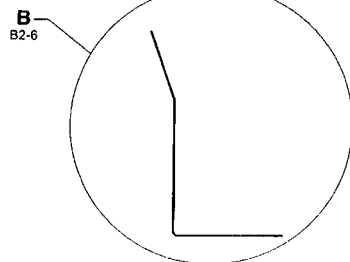
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D

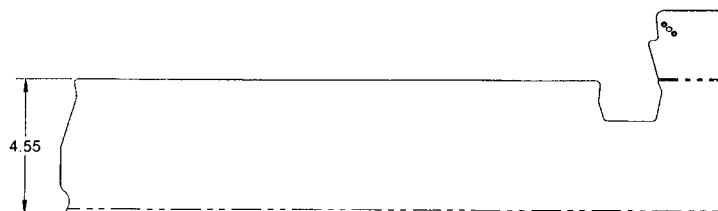
C

B

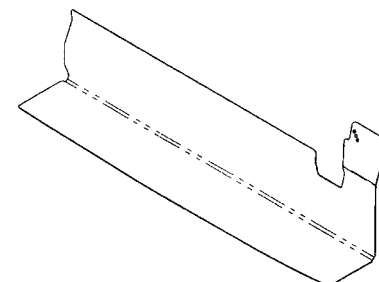
A



B  
B2-6



4.55

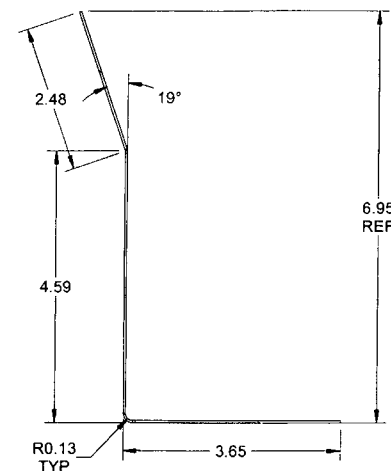


D

C

B

A



R0.13  
TYP

**DETAIL B** C8-6  
SCALE 2X

# **D4434-1 BRACKET**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

**RELEASED**  
2012-03-02

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 6 OF 15
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	<b>COVER ASSEMBLY</b>	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



8

7

6

5

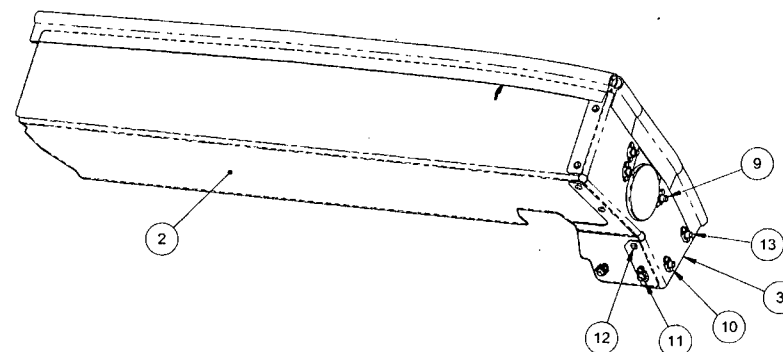
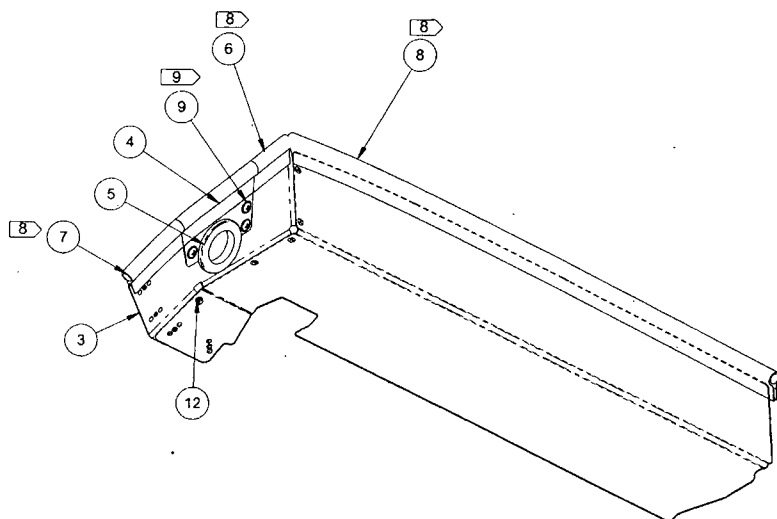
4

3

2

1

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE



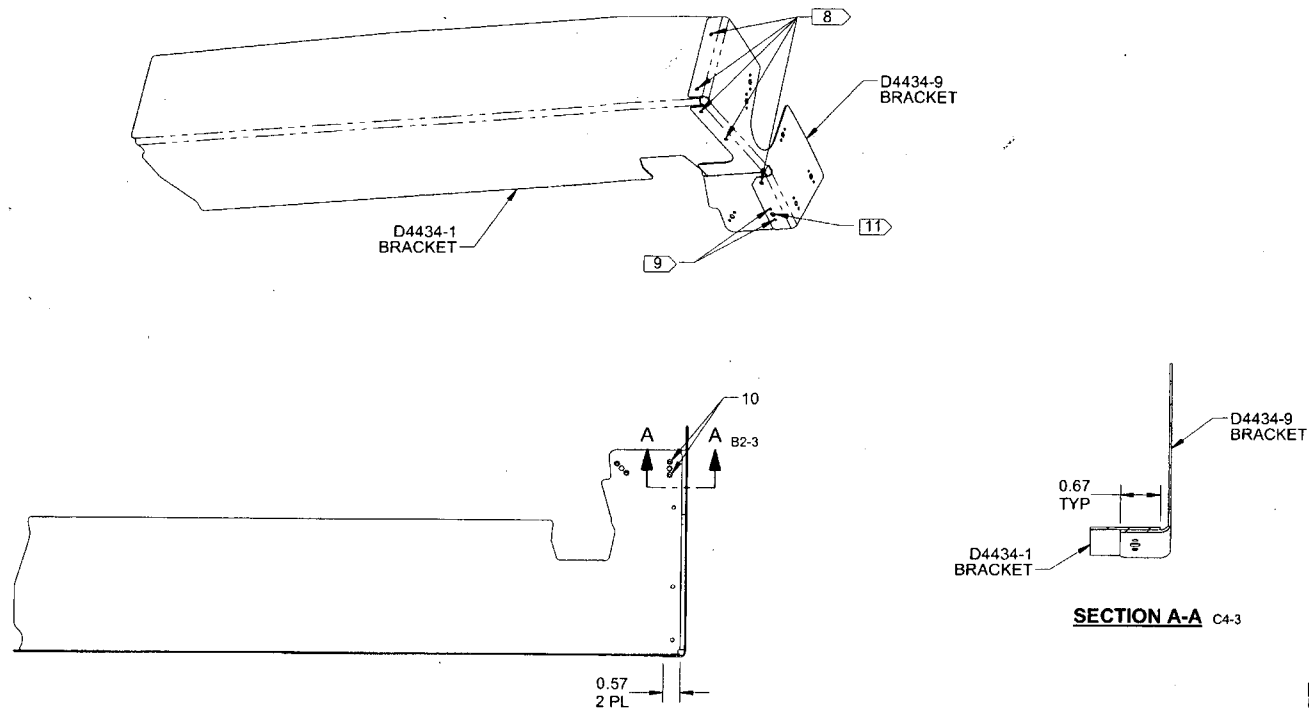
### D4434-043 FWD INBOARD BRACKET ASSEMBLY

RELEASED  
2012-03-02

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
- 9) TORQUE SCREW TO 12-15 (in-lb)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4434	REV. B
MFG. APPR.	RF	SHEET 2 OF 15	
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER  $\varnothing 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER  $\varnothing 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK  $\varnothing 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
- 11) TRANSFER  $\varnothing 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

## **D4434-043 FWD INBOARD BRACKET ASSEMBLY** AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	<b>D4434</b>	SHEET 3 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	<b>COVER ASSEMBLY</b>	NTS
DATE	12.02.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
2012-03-03  
*W*

8 7 6 5 4 3 2 1

D

C

B

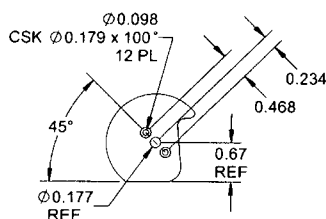
A

D

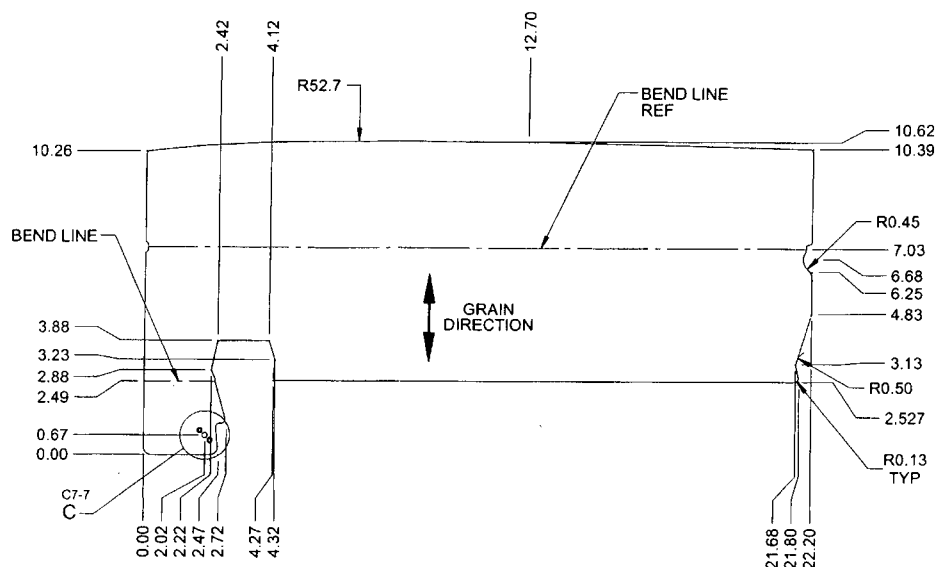
C

B

A



**DETAIL C** B6-7  
SCALE 2X



**D4434-1F FLAT PATTERN**

**RELEASED**  
2012-03-02  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	<b>D4434</b>	SHEET 7 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>COVER ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1